

Amendments to the Claims:

This listing of the claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1-8. (Cancelled)

9. **(Currently Amended)** A method for the manufacture of sheets of corrugated board on a corrugating machine, comprising the following steps:

providing a corrugating machine which comprises at least two unroll stands for unwinding continuous webs of material as well as at least one processing equipment for producing at least one web of corrugated board from the webs of material;

determining the distances between adjacent marks (17, 18) on at least one of the webs of material (3) with at least one measuring device (19, 44; 19, 75, 76; 44; 75, 76) being in signaling connection with a control device (7);

determining a degree of shrinkage in at least one direction of the webs of material (3, 8, 22) based on the ratio of the distances of the marks (17, 18);

determining scaling factors for the printing pattern by the control device (7) so that the desired size of the printing patterns will appear on the web;

digitally printing ~~the printing pattern on~~ at least one web of material on the corrugating machine ~~in accordance with the determined scaling factors~~; and

cutting the sheets of corrugated board from the digitally printed web of corrugated board in accordance with the shape and size of ~~the~~ digitally imprinted ~~patternspattern.~~

10. **(Withdrawn)** A method according to claim 9, wherein two webs of material are digitally printed prior to being united to form a web of corrugated board.

11. **(Original)** A method according to claim 9, wherein at least one web of material is printed digitally after it has been joined to at least a second web of material, forming a web of corrugated board.

12. **(New)** A method for the manufacture of sheets of corrugated board on a corrugating machine, comprising the following steps:

providing a corrugating machine which comprises at least two unroll stands for unwinding continuous webs of material as well as at least one processing equipment for producing at least one web of corrugated board from the webs of material;

determining the distances between adjacent marks on at least one of the webs of material with at least one measuring device being in signaling connection with a control device, the adjacent marks comprising a first plurality of marks extending in a first direction parallel to the moving direction of the webs of material, and a second plurality of marks extending in a second direction perpendicular to the moving direction of the webs of material;

determining a degree of shrinkage in the first and the second direction of the webs of material based on the ratio of the distances of the adjacent marks;

determining scaling factors for the printing pattern by the control device responsive to the degree of shrinkage in the first and second directions so that the desired size of the printing patterns will appear on the web;
digitally printing the printing pattern on at least one web of material on the corrugating machine in accordance with the determined scaling factors; and cutting the sheets of corrugated board from the digitally printed web of corrugated board in accordance with the shape and size of the digitally imprinted pattern.